

Date: Wednesday, 12/13/2006 2:41:31 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP LEG
Job Number :	29922B		
Estimate Number :	10353		
P.O. Number :	N/A	Part Number :	D2278
This Issue :	12/13/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2278 REV E
First Issue :	N/A	Project Number :	N/A
Previous Run :	29846	Drawing Revision :	E
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	1/5/2007
Written By :	Qty:		40 Um: Each
Checked & Approved By :	<i>[Signature]</i> 061213		
Comment :	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick 11.3366
 (M6061T62S.080)
 Identify as D2278 29.8874 M103713
 Batch: M103434 m1070307

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2278
 Dwg Rev: E
 Prog Rev: E

2-Deburr if necessary

ml

07/03/07

07/03/17

40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/04

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/08

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

yl / m / e

07-03-20

Dart Aerospace Ltd.
 W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 29922B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 7/3/20 40

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: 7/3/20

Handwritten: SP H63/20 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Handwritten: (40)

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 07/03/20

Job Completion



Handwritten: U 07-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

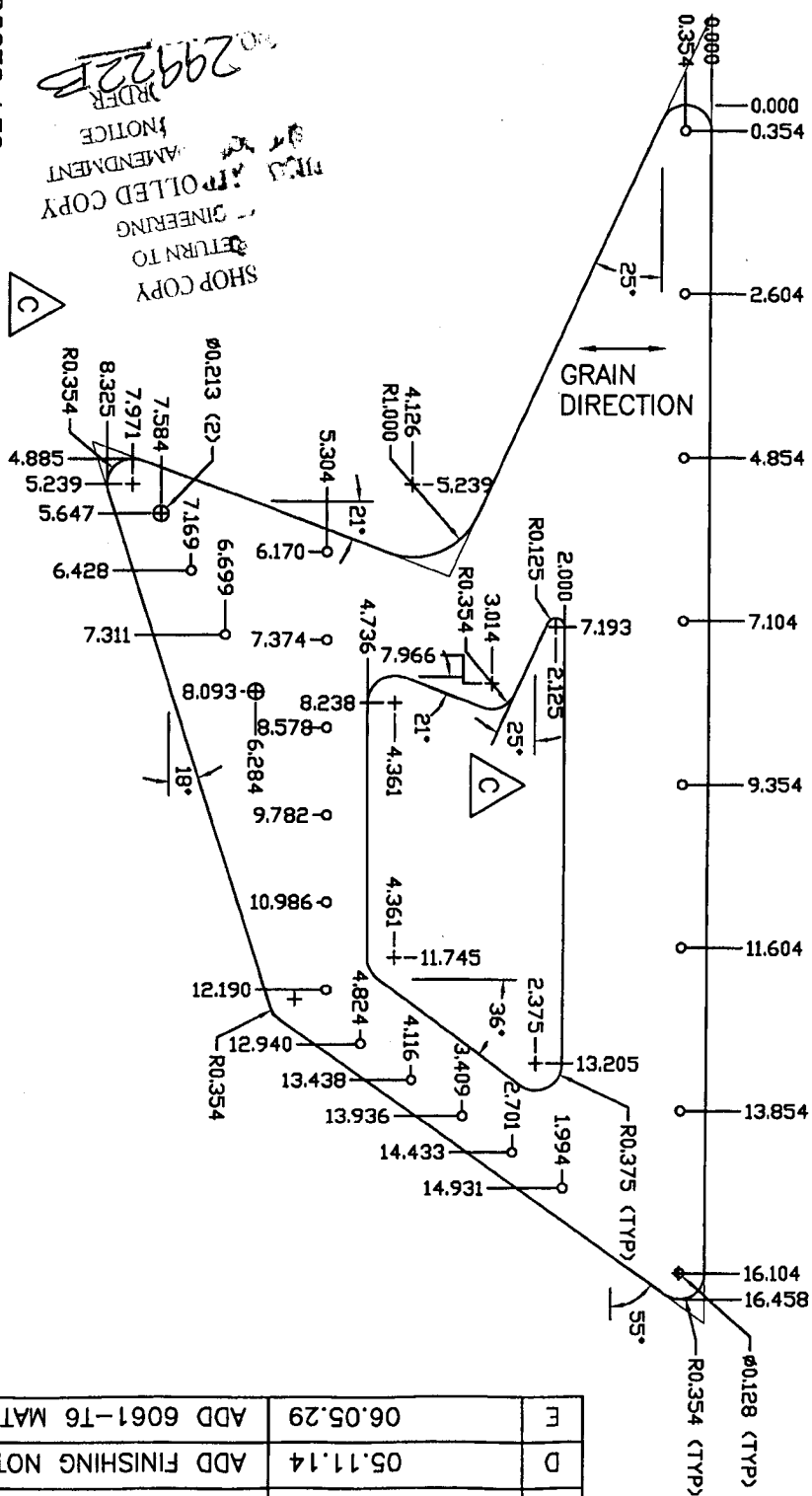
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Oct. 20 - 7



D2278 LEG
1) MATEF


6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR
AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR

2) **FINISH:**

5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) ALL DIMENSIONS ARE IN INCHES

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E SHEET 1 OF 1 D2278 DRAWING NO.	CHECKED PH APPROVED 	DATE 06.05.29	TIME LEG	SCALE 1:2.5	C 95.02.16 CHANGED RADIUS TO 0.354	D 05.11.14 ADD FINISHING NOTE	E 06.05.29 ADD 6061-T6 MATERIAL
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DART

